

Work Order ID 77571

77571

Page 1

December-13-11 1:53:12 PM

Item ID: D3278-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 13/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								

100
100 SHEAR 0.00
Bandsaw Memo 0.00
Jeaspa Bandsaw Cut blank: 2.00" x 1.00" x 2.550" long SL 12-01-07 HC

110
110 HAAS CNC VERTICAL MACHINING #1 0.00
HAAS I Memo 0.00
HAAS CNC vertical machine #1 1- Machine as per Folio FA405 and Dwg D32782- Deburr and TumbleIdentify as D3278-2 OK 12/01/07 40 ✓

120
120 QC2- Inspect parts off machine FAI/FAIB 0.00
QC Memo 0.00
Quality Control OK 12/01/07 40 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:30								
	FINISH TIME: 9:00								

m 11a480

3200F

9:00

40x4 M/L 12/01/10

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Item ID: D3278-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 13/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

No. B2 12-1-10.

170 Identify as per dwg & Stock Location: G-A

0.00

170

Packaging

Memo

0.00

Packaging

12/01/12 (40)

180 QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/1/12

ME 12-01-12

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NOTE: Date & initial all entries

Picklist Print

December-13-11 1:53:17 PM

Page 1

Work Order ID: 77571

77571

Parent Item: D3278-2

D3278-2

Parent Item Name: Support

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased		No		100	f	23.6460	0.2337	9.84			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

**

JL 12-01-07

Location

Loc Qty

Loc Code

MAT003

23.646

112567

16.6

118106

7.046

120044

9.85

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 77571
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099	—		Vern ML-06	
0.359	+/-0.005	.359	—			
0.609	+/-0.010	.614	—			
0.250	+/-0.010	.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	R.125	—		R-G	
0.119	+0.005/-0.004	.121	—		Vern ML-06	
2.439	+/-0.010	2.439	—			
1.980	+/-0.010	1.980	—			
R0.13	+/-0.030	R.125	—		R-G	
Ø0.257	+0.005/-0.000	Ø.258	—		Vern ML-06	
R0.375	+/-0.010	R.375	—		R-G	
0.875	+/-0.010	.874	—		Vern ML-06	
0.500	+/-0.010	.500	—			
R0.400	+/-0.010	R.400	—		R-G	
R1.00	+/-0.030	R.1.00	—		"	
1.720	+/-0.010	1.721	—		Vern ML-06	
R0.125	+/-0.010	R.125	—		R-G	
0.125	+/-0.010	.124	—		Vern ML-06	

Measured by: <i>cmf</i>	Audited by: <i>DA</i>	Prototype Approval:	N/A
Date: 12/01/07	Date: 12/1/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>JE</i>

W/O:		WORK ORDER CHANGES					
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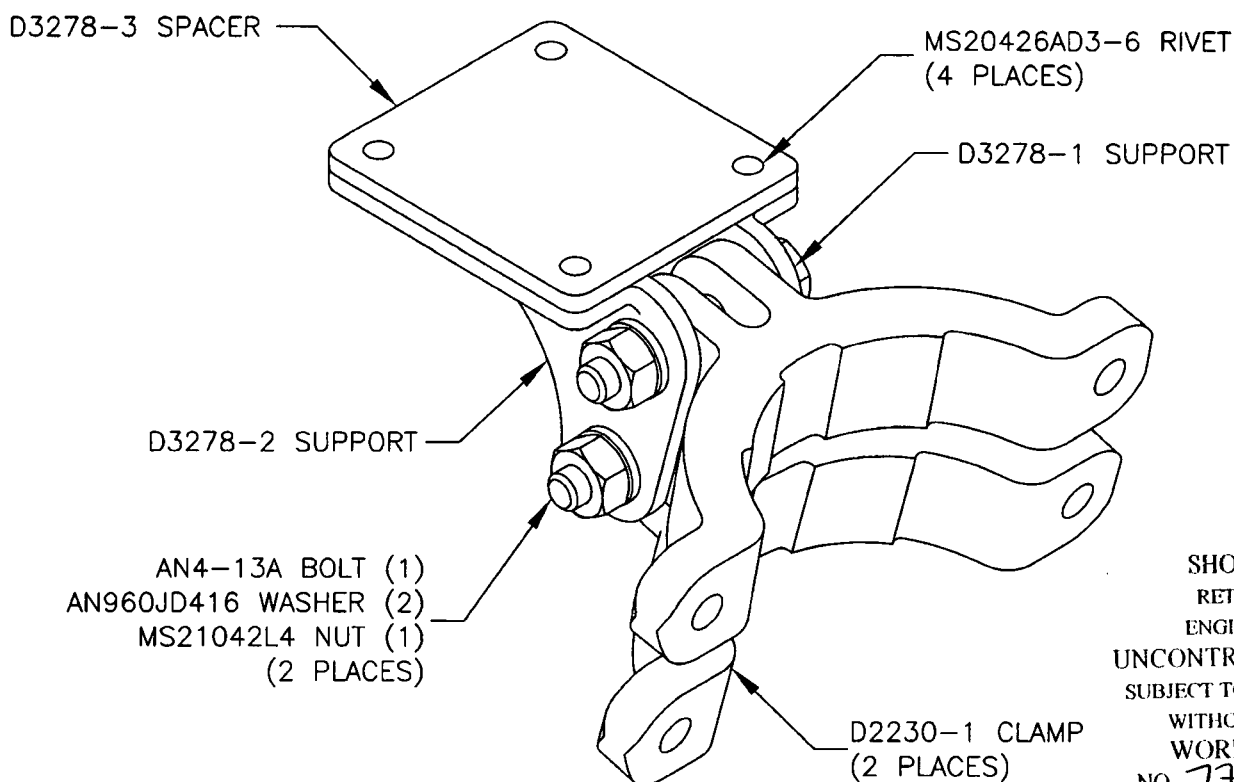
NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-46

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77571
M.L.J.
11/12/13

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

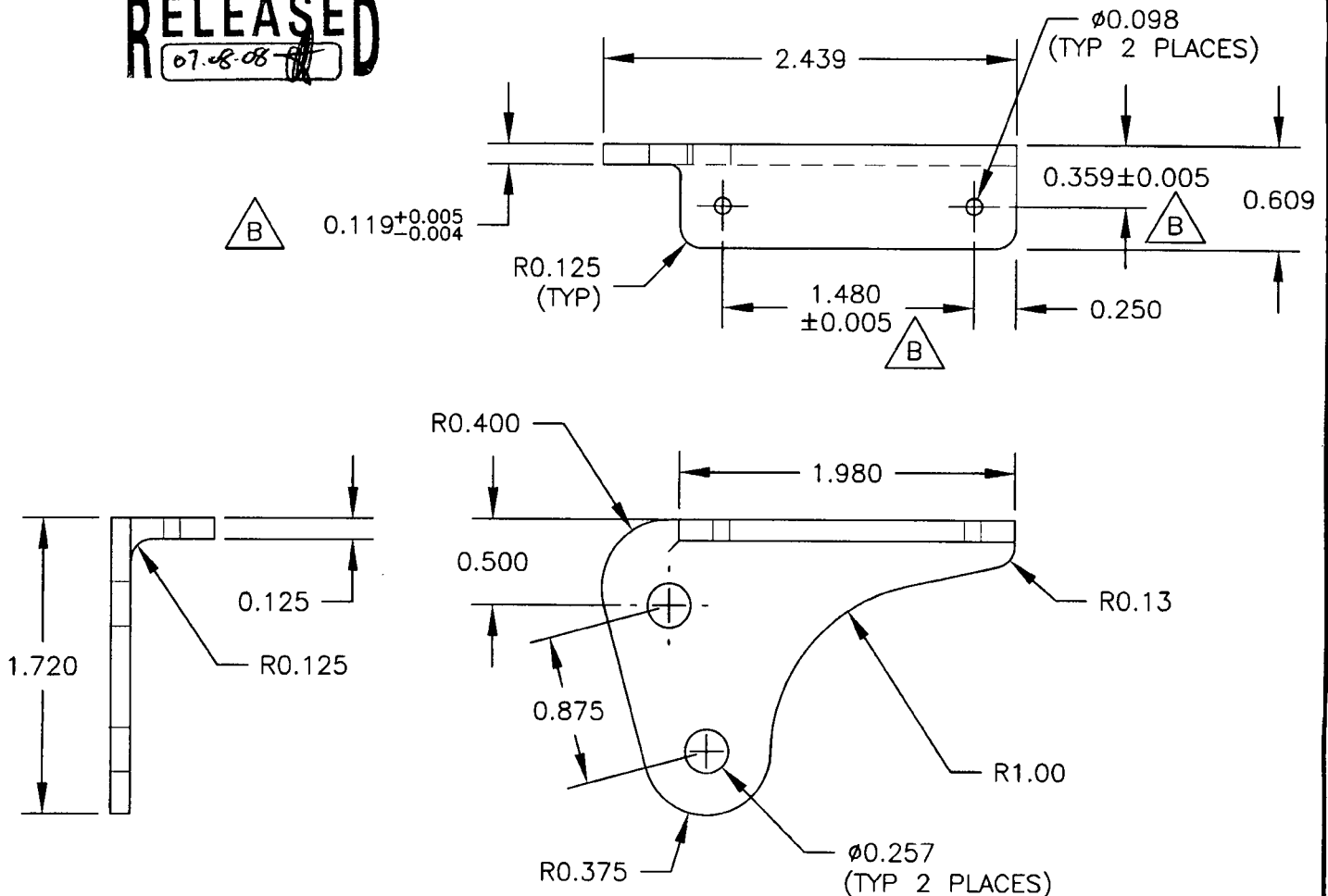
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NOTE: Date & initial all entries

DART

77571

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

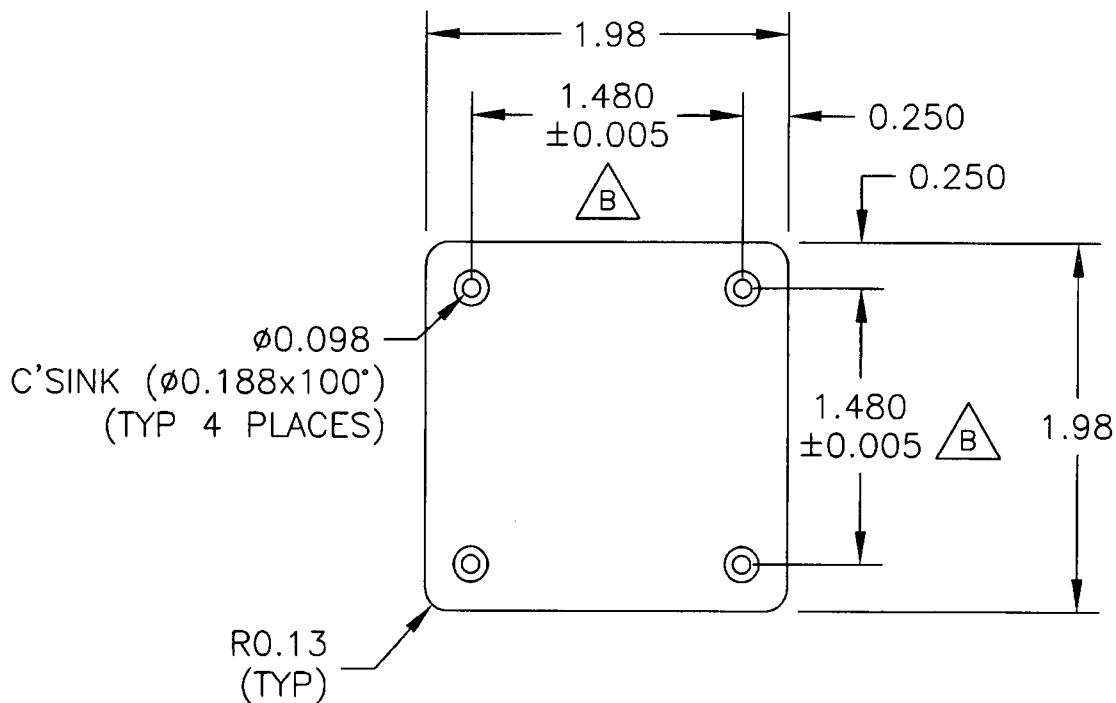
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

77571

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries